

Work Order ID 131607

Monday, April 20, 2015 10:10:06 AM

646.3015
B 131607
REV. N/C

131607

Page 1

Item ID: 646.3015

Revision ID:

Item Name: Blade

Start Date: 4/20/2015 Start Qty: 4.00

Required Date: 4/20/2015 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MCS Date: 1504-20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

646.3000

N/C

100

0.00

100

BAND SAW

Bandsaw

Memo

Cut Blank at 6.580"

Jeaspa Bandsaw

150407

4

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

1-Machine per folio FB150

DWG REV: NC

FOLIO REV: NC

HAAS CNC vertical machine #1

150427

4

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Monday, April 20, 2015 10:10:06 AM

131607

Page 2

Item ID: 646.3015 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blade
Start Date: 4/20/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/20/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Outsource process - Heat Treat	0.00							
140									
Outsource1	Memo	0.00							
Outsource process - Heat Treat	HEAT TREAT AS PER DWG, SEE NOTE #3								
	ISSUE P/O: <u>28564</u>								

Handwritten notes and stamps:
- Next to 120: *150427*
- Next to 130: *4*, *0*, *DAS 37 9-89 15.04.28*
- Next to 140: *CY*, *MAR 21 2015*, *4*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Spray Painting per QSI005 4.2	0.00							
160									
SprayPaint	Memo	0.00							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: <u>131277</u>								

4X 8015-06-01

(4) **DAS 38 9-89**
JUN 01 2015

4 **DAS 41 9-89**
15-6-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 131607

Monday, April 20, 2015 10:10:06 AM

131607

Page 4

Item ID: 646.3015 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade
 Start Date: 4/20/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/20/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC14- Inspect Spray Paint	0.00				3	1		DAS 38 9-89
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: MF	0.00				3	MC		DAS 27 9-89
180									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

P.T.O.

JUN 18 2015

JUN 18 2015

JUN 22 2015

JUN 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : <u>15-06-18</u>		Step #: <u>110</u>		QTY Effective : <u>1</u>			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification DAS <u>38</u> 9-89 <u>JUN 18 2015</u> QC / QA Coordinator DAS Approval <u>9</u> 9-89 <u>150618</u>			
<u>found/mark (0.600 by 0.100) while expected (mark was made between machining and Heat treat)</u> <u>RC: Hand lting</u>				<u>Scrap / destroy</u> <u>no replace</u>							
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☒	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☒	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

Picklist Print

Monday, April 20, 2015 10:10:09 AM

Work Order ID: 131607

131607

Parent Item: 646.3015

646.3015

Parent Item Name: Blade

Start Date: 4/20/2015

Required Date: 4/20/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 12/11/09 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased		No		100	f	137.4770	0.549	3			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

Location

MAT010

M126438

M131783

Loc Qty

137.477

9.477

128

Loc Code

150427

1.875'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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		OTHER : ☐																																																																		

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

02195

SHEET 1 OF 4

DWG NO. 646.3000

REV: N/C

PREPARED BY

S. HUFF

DATE: 01/05/09

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE:

LOWER CUTTER ASSY

APPROVED BY:

ENGR

MFG

QC

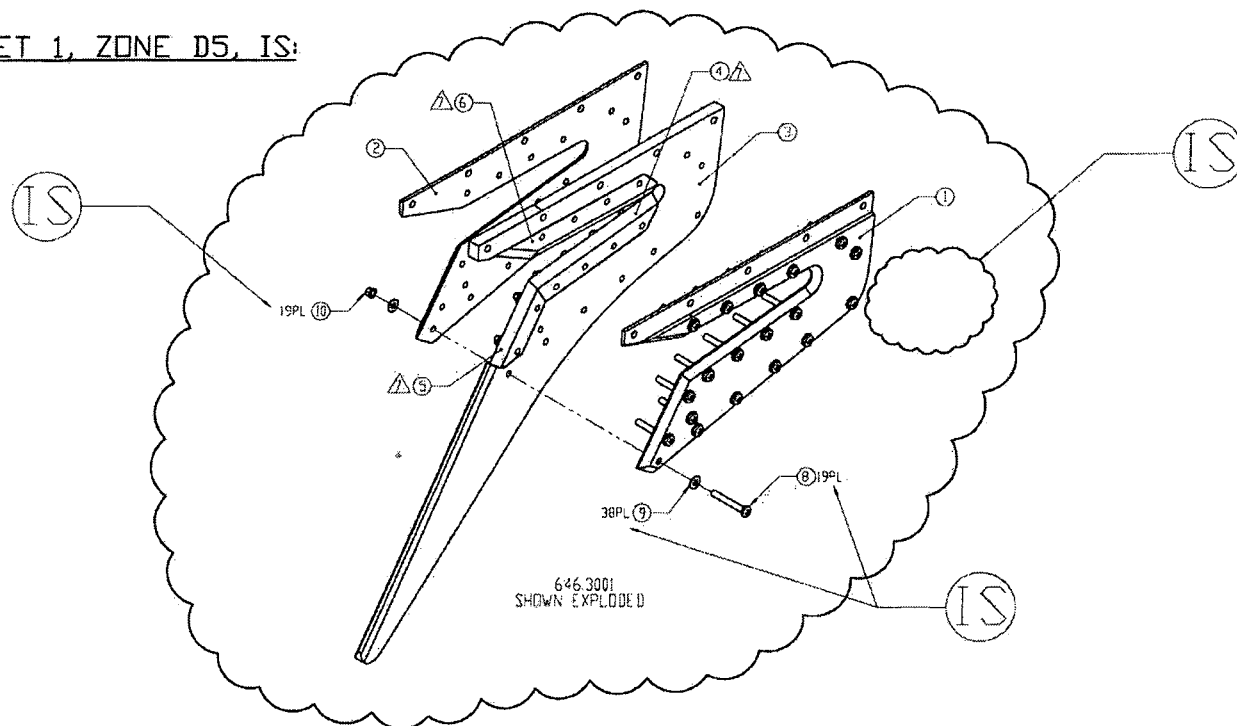
EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS

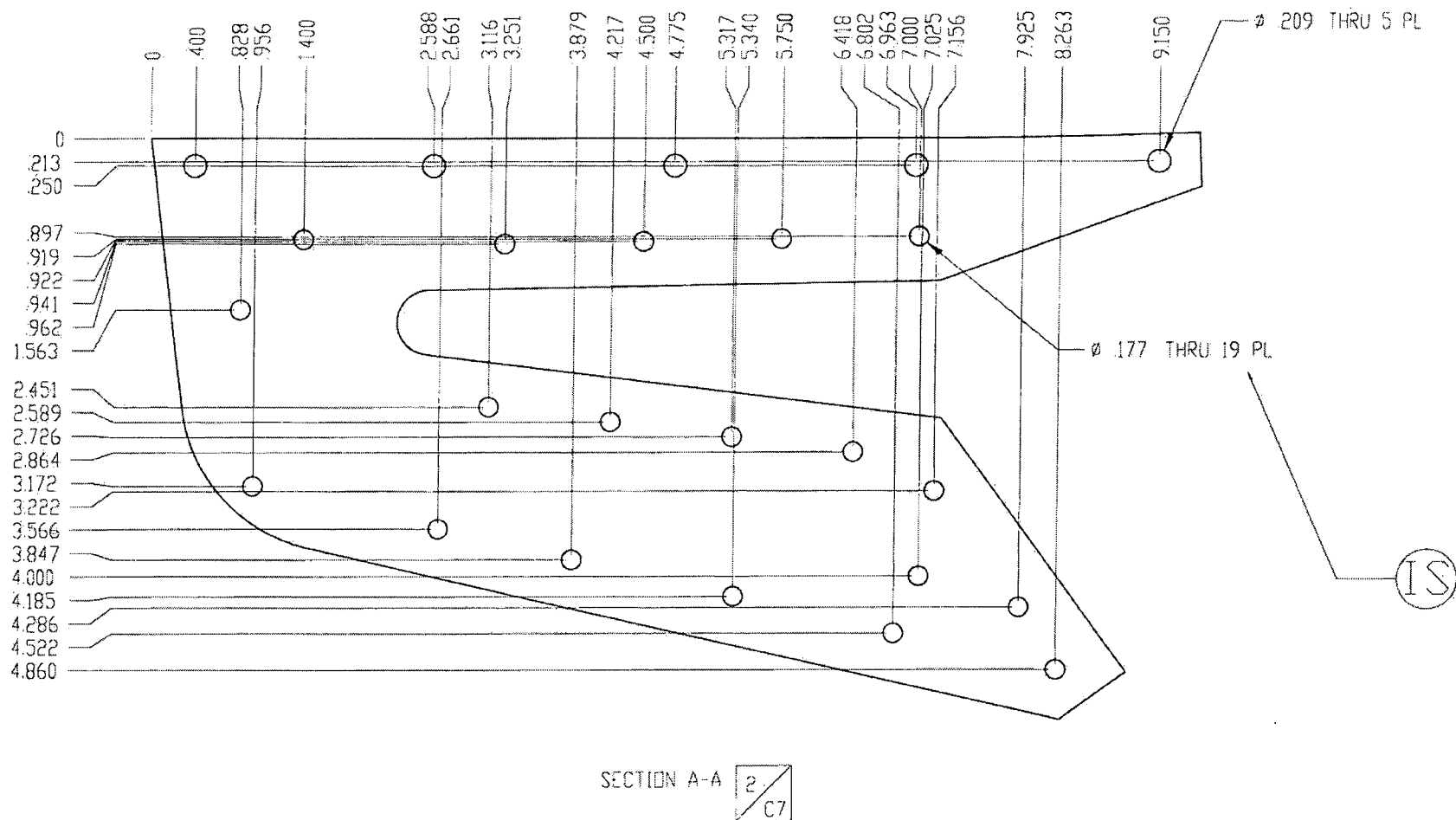
SHEET 1, ZONE D5, IS:



SHOW BY
UNION
SPEL
131607.MW
1504-20

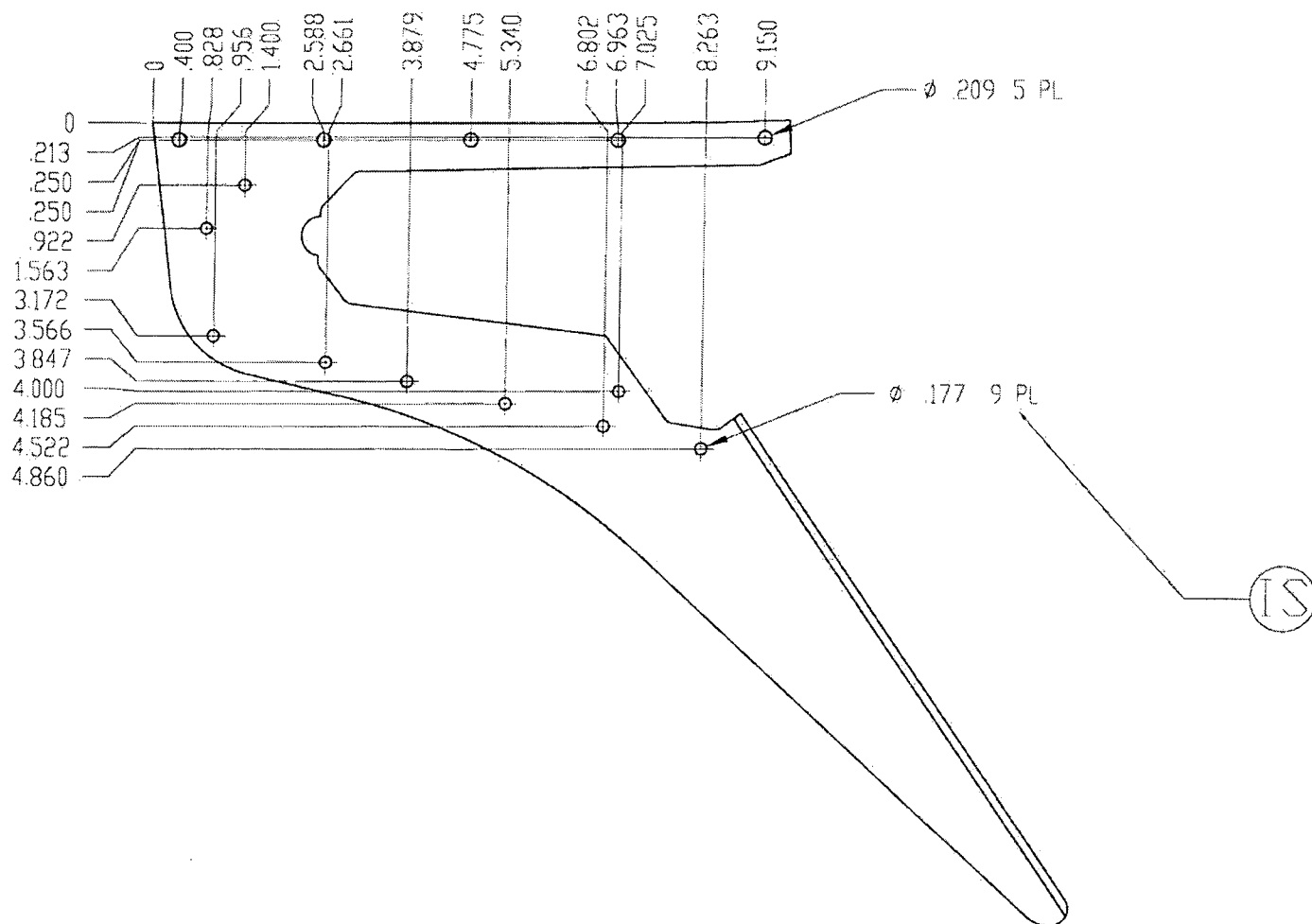
10	R	601.1541	19	LOCKNUT	MS21042L08
9	R	601.2764	38	WASHER	NAS1149FN832P
8	R	601.2765	19	SCREW	MS27039-0819
7	D	601.2766	2	RIVET	MS20470AD5-18
			.3001		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☒ INSTALL INSTRUCC ☒ ICA ☐ FMS ☒ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR
				DER REVIEW REQUIRED ☐ YES ☒ NO	

SHEET 3 IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 5 IS:

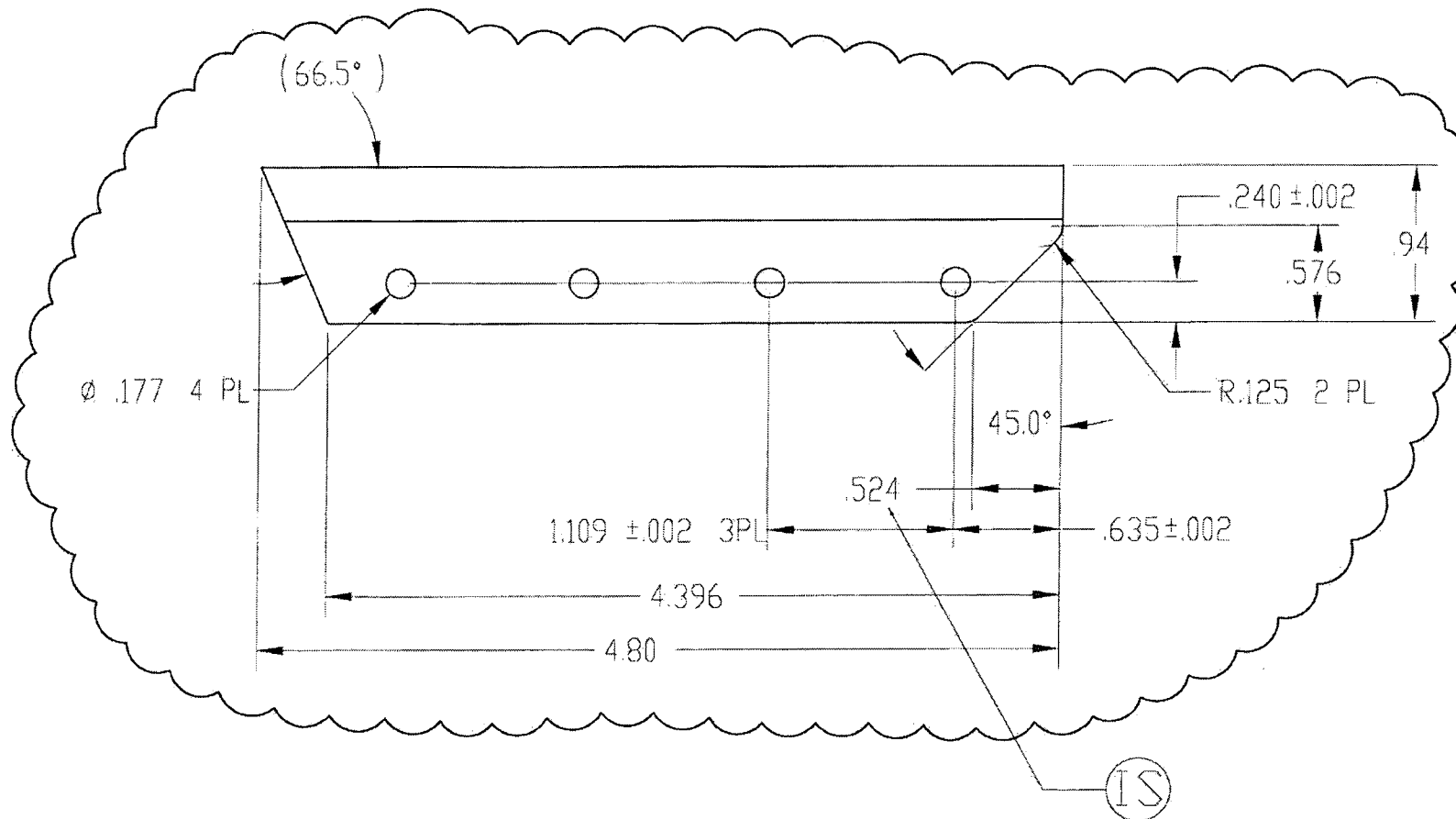


SECTION F-F



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 6, ZONE C4, IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

NOTES:

- 2
- HARDNESS
OTHERWISE NOTED
- OF F/N 4, 5 & 6 UPON ASSEMBLY
SHARP EDGE
- 17PL (10)
- (7) (6)
- (2)
- (4) (7)
- (3)
- (1)
- (7) 2PL
- (5)
- (8) 17PL
- 34PL (9)
- UNINCORPORATED
- 02195
- 646.3001
SHOWN EXPLODED
- | | | A/P | 11 | 601.2045 | RTV, LOCTITE 598 |
|--|--|-----|----|----------|------------------|
| | | 17 | 10 | 601.1868 | LOCKNUT |
| | | 34 | 9 | 601.2764 | WASHER |
| | | 17 | 8 | 601.2765 | SCREW |
| | | 2 | 7 | 601.2766 | RIVET |
| | | 1 | 6 | 646.3015 | BLADE |
| | | 1 | 5 | 646.3014 | BLADE |
| | | 1 | 4 | 646.3013 | BLADE |
| | | 1 | 3 | 646.3012 | LOWER GUIDE |
| | | 1 | 2 | 646.3011 | RH HALF |
| | | 1 | 1 | 646.3010 | LH HALF |
| | | X | | 646.3001 | LOWER CUTTER |

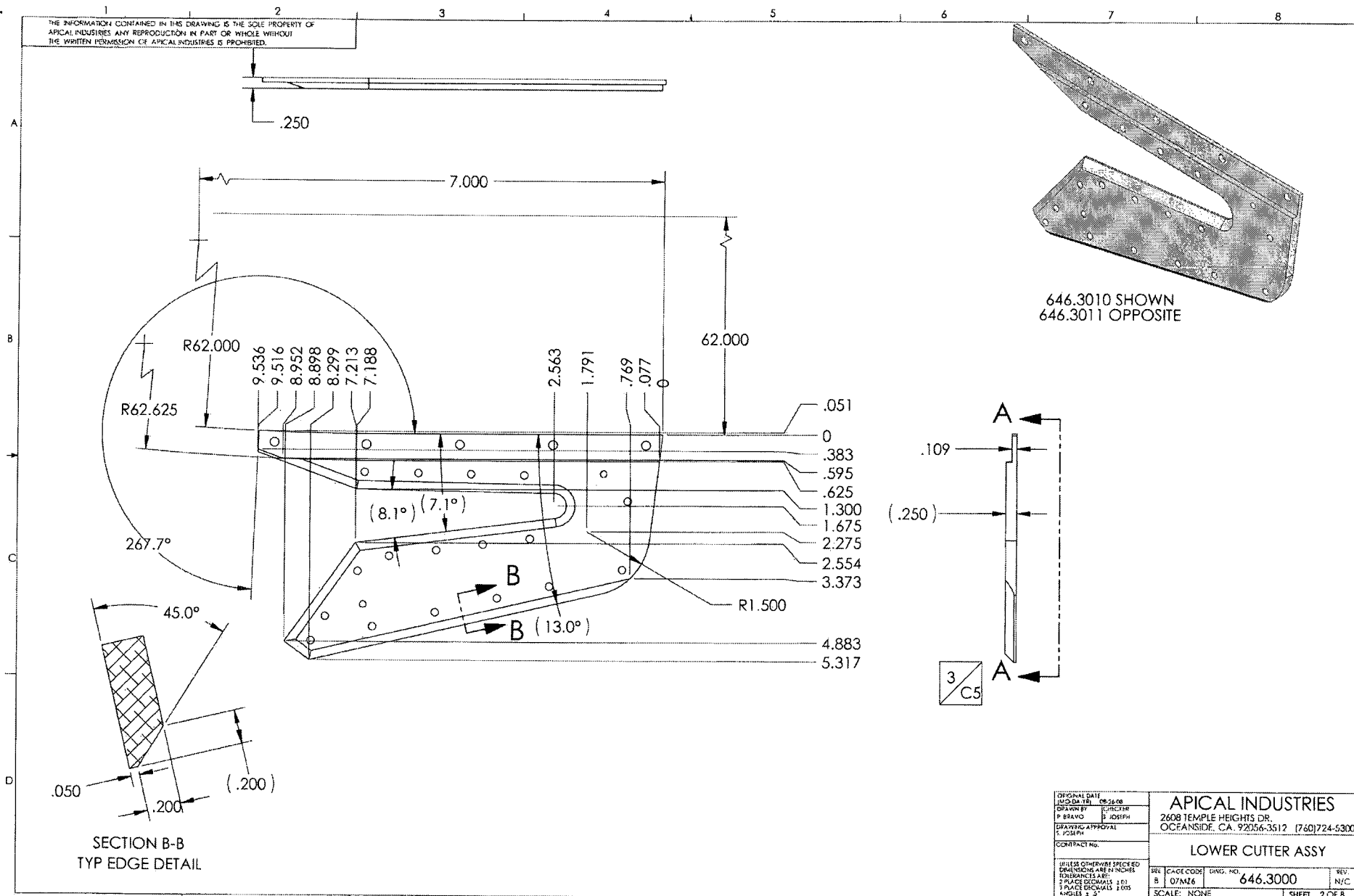
646.3001
SHOWN EXPLODED

UNINCORPORATED ECN(S)

02195

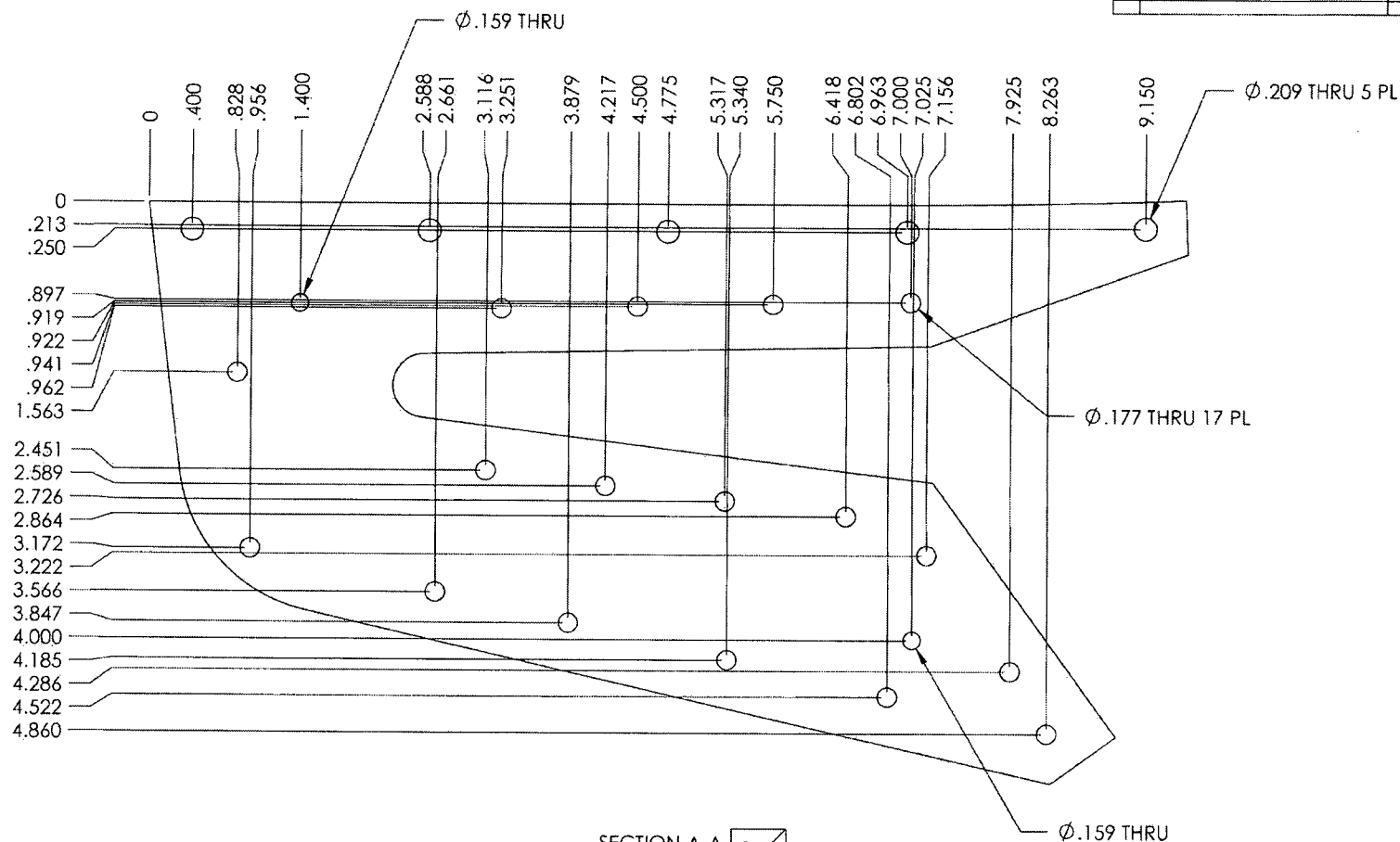
[illegible]

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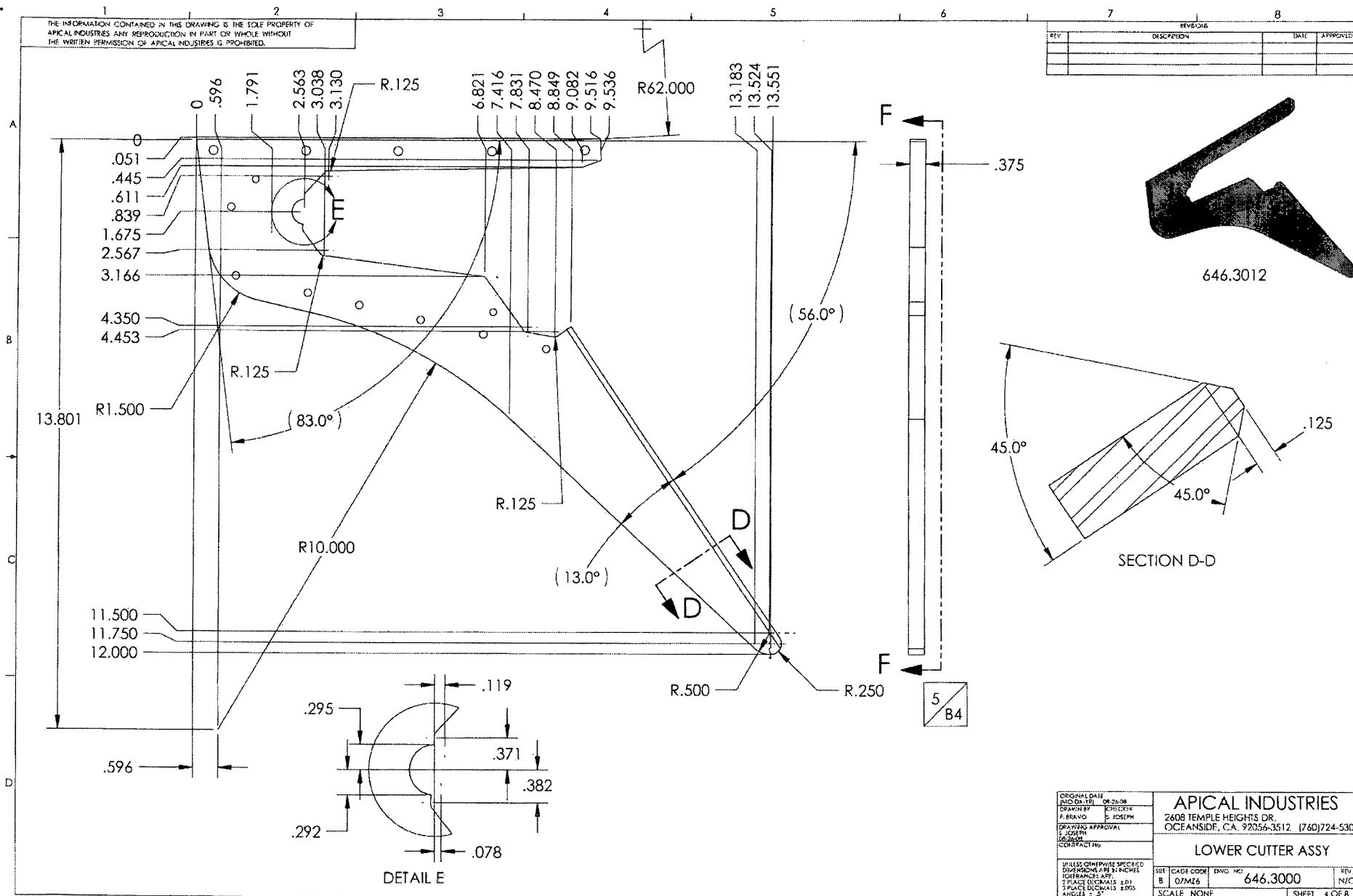
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE: 05/24/01		APICAL INDUSTRIES	
DRAWN BY: J. JOSEPH		2608 TEMPLE HEIGHTS DR.	
P. BRADY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL: J. JOSEPH		LOWER CUTTER ASSY	
DATE: 05/24/01		SCALE: NONE	
CONTRACT NO.		SHEET 3 OF 6	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV: N/C	REV: N/C

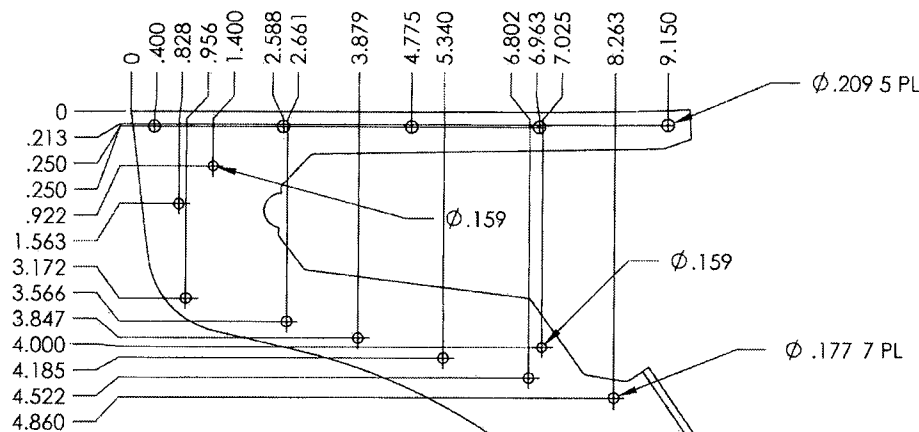
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REV		DESCRIPTION	DATE	APPROVED



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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



SECTION F-F



ORIGINAL DATE (M/D/Y)		08-24-05	
DRAWN BY		T. JOSEPH	
P. BRAVO		S. JOSEPH	
DRAWING APPROVAL		08-24-05	
CONTRACTING			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. FRACTIONS: .001 2. DECIMALS: .001 3. ANGLES: .5°			
REV.	CAGE CODE	DWG. NO.	REV.
8	07M26	646.3000	N/C
SCALE: NONE		SHEET 5 OF 8	

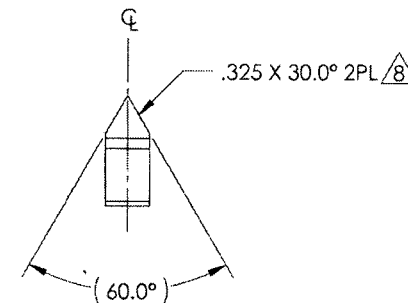
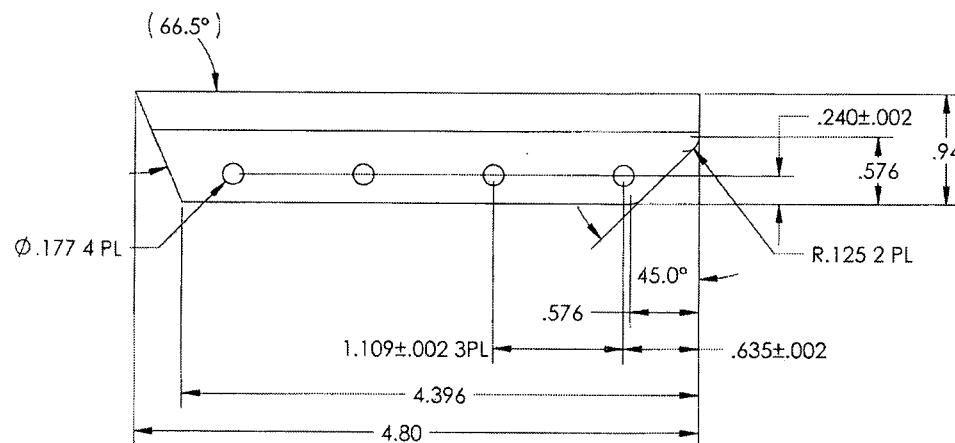
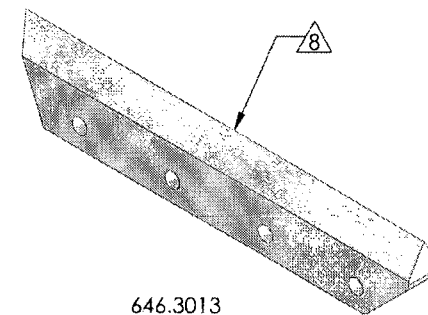
APICAL INDUSTRIES

2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

LOWER CUTTER ASSY

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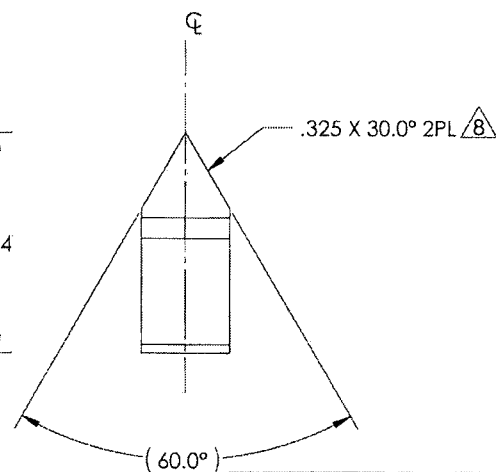
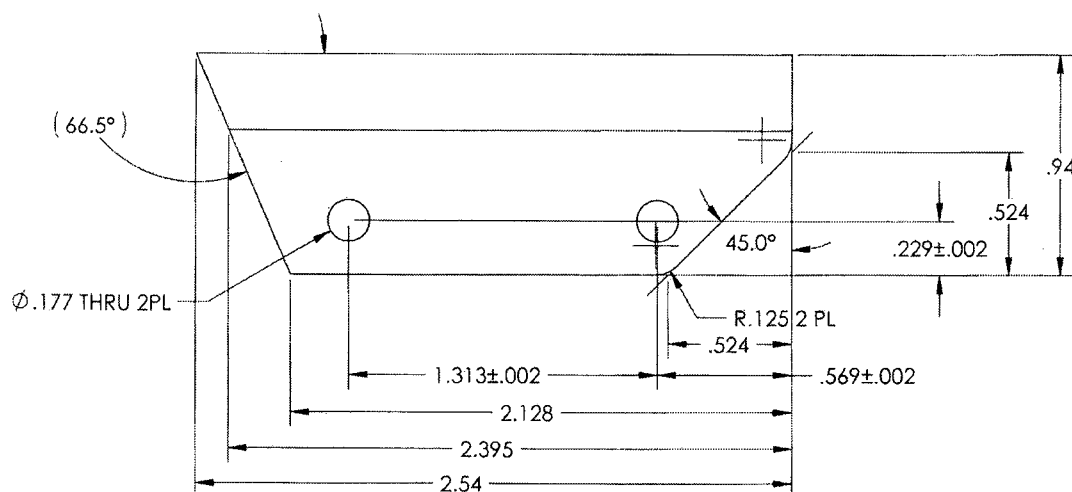
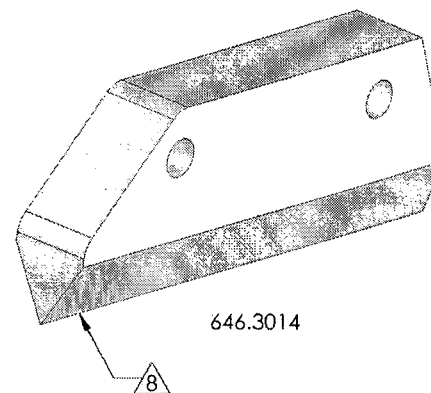
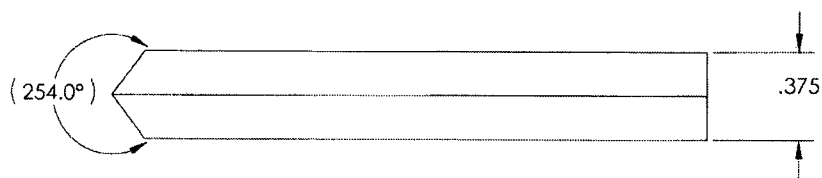
REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE 10/24/11	DESIGNED BY J. JOSEPH	APICAL INDUSTRIES	
DRAWN BY J. JOSEPH	CHECKED BY J. JOSEPH	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL J. JOSEPH		LOWER CUTTER ASSY	
CONTRACT NO.		REV. N/C	DATE 10/24/11
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SCALE NONE	SHEET 6 OF 8

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

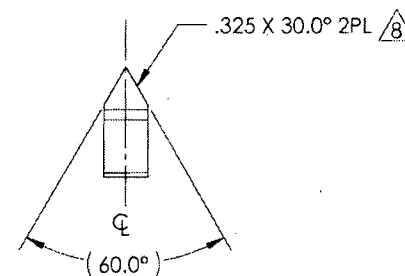
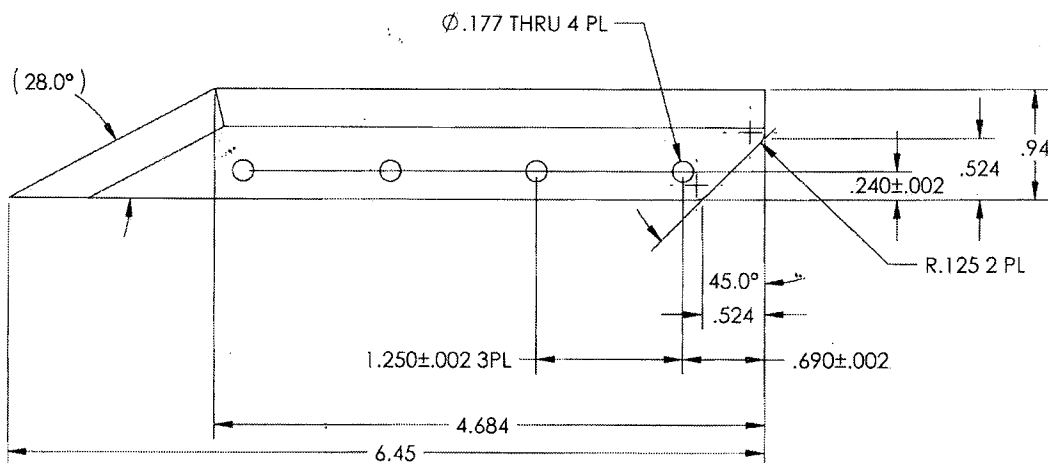
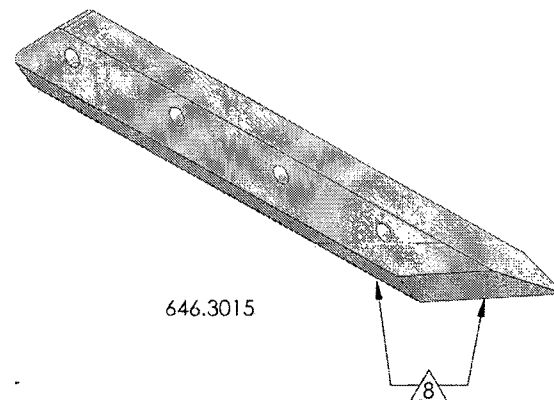
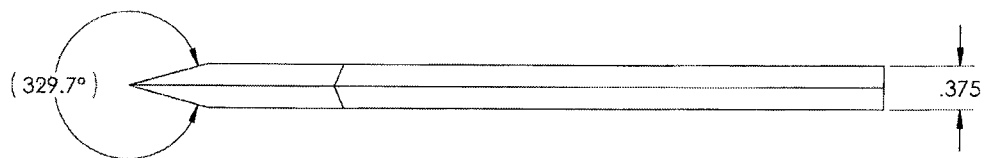
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE: 06-29-08		APICAL INDUSTRIES	
DRAWN BY: K. HILTY		2408 TEMPLE HEIGHTS DR.	
P. BRAYD		OCEANSIDE, CA. 92056-3512	
DRAWING APPROVAL: S. JOSEPH		(760) 724-5300	
REVISION:		LOWER CUTTER ASSY	
CONTRACT NO:		646.3000	
UNLESS OTHERWISE SPECIFIED		SCALE: NONE	SHEET: 7 OF 8
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE:			
FRACTIONS DECIMALS .01			
FRACTIONS DECIMALS .005			
ANGLES: ± .5°			

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REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE (MM-DD-YY) 09-26-00 DRAWN BY P. SPANO CHECKED BY L. JOSEPH DRAWING APPROVAL (Signature) (Signature) (Signature)	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± 5°	LOWER CUTTER ASSY SHEET 8 OF 8 SCALE NONE DATE 07/26/00 QTY 646.3000 REV N/C



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28564**

Purchase Order Date 5/21/2015

PO Print Date 5/21/2015

Page Number 1 of 2

Order From :

VC-MET004

Ship To : DART AEROSPACE LTD

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	131607	646.3015 BLADE	6/17/2015 Yes 6/17/2015		4.00 ✓	\$0.00	\$0.00
	FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS						
	PART ARE MADE FROM AISI A2 TOOL STEEL						
	PLEASE NOTE: DETAIL C OF C REQUIRED						
					<i>Sp/15-de-01</i>		
					Line Total:		\$0.00
2	131616	D2741 BLADES	6/17/2015 Yes 6/17/2015		32.00	\$0.00	\$0.00
	HARDEN MATERIAL: ULTIMATE TENSILE STRENGTH = 152 KSI MINIMUM YIELD TENSILE STENGHT = 141 KSI (34-40 HRC) SAND BLAST PART AFTER HEAT TREAT						
	NOTE: DETAIL C OF C REQUIRED						

Note:

5/21/2015

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison.

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
302561	1	102655

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
28564		A2	2015/5/22	FED

QUANTITÉ Quantity	No. PIÈCE Part No.	NOM DE LA PIÈCE Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-----------------------	------------------------------	---	-----------------

✓ 4 646.3015
(4) 646.3015
BLADE
131607

2,

1 SAC DE PLASTIQUE

Sp15-06-01

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
SAC DE PLASTIQUE	1	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 4

POIDS EXPÉDIÉ / Weight Shipped : 2,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 4

POIDS EXPÉDIÉ / Weight Shipped : 2,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2015/05/26

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Rapport d'Inspection**Inspection Report**

BON DE TRAVAIL order	CHARGEMENT load
302561	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

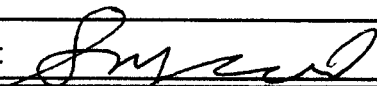
COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
28564		A2		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results				
HARDNESS		58 - 62 HRC	4	60 - 61 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
4	2	848.3015 (4) 848.3015 BLADE 131607 1 SAC DE PLASTIQUE		

SP 15-06-01

1506

COMMENTAIRES / comments

APPROUVÉ par / Approved by:




DATE: 2015-05-26

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
302561	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
28564		A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results				
HARDNESS		58 - 62 HRC	4	60 - 61 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
4	2	646.3015 (4) 646.3015 BLADE 131607 1 SAC DE PLASTIQUE		

COMMENTAIRES / comments

VAC HARDEN 1800F, 1HR 30MIN
DOUBLE TEMPER 400F, 2HRS

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by: <i>Vincent Costello</i>		DATE: 2015-05-26
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